

Date: Tuesday, 5/13/2008 3:53:31 PM
 User: David Duval

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : WEARSHOE

Job Number : 39253

Estimate Number : 13315

P.O. Number :

Part Number : D37933

This Issue : 5/13/2008 S.O. No. :

Drawing Number : PRELIM

Prsht Rev. : NC

Project Number : N/A

First Issue : 1-1

Type : R & D SM/MED FAB

Drawing Revision : PRELIM

Previous Run :

Material :

Due Date : 5/20/2008

Qty: 2 Um: Each

Written By :

Checked & Approved By :

Comment : Est Rev:A 08-05-13 new issue DD verified by:

Additional Product

FOR ENGINEERING USE ONLY

~~PROTOTYPE~~

Job Number:

~~PRELIMINARY ISSUE~~

Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet



Comment: Qty.: 0.5733 sf(s)/Unit Total : 0.5733 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: 07 909 B 8-5-14

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3793

Dwg Rev: PRE.L

B 8-5-14

Prog Rev: PRE.L

2-Deburr if necessary

B 8-5-14

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 8-5-14

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

080514

2

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3793 using Jigs

080514

2

Date: Tuesday, 5/13/2008 3:53:31 PM
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Drawing Name: WEARSHOE

Job Number: 39253

Part Number: D37933

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Form Joggle on brake using Jig as per Dwg D3793

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

RAH 08.05.14

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

N/A *RAH* 08.05.16

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Ens's lab

NOT FOR STOCK *RAH* 08.05.21

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



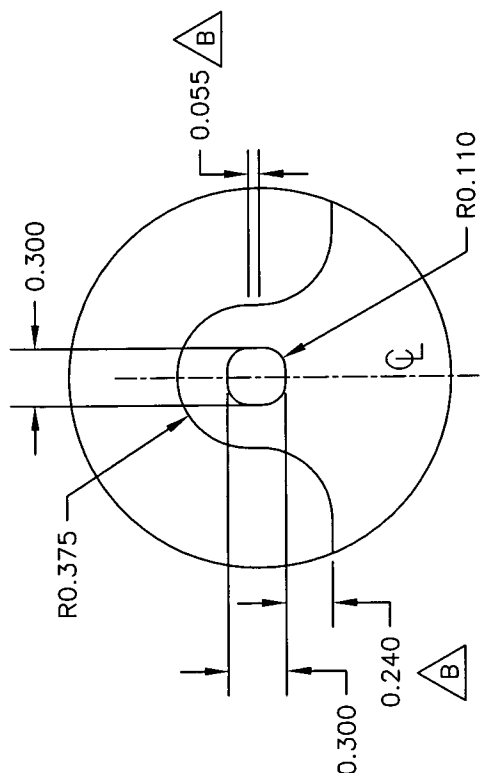
MF 08-05-16
POSITIVE RECALL

EFFECTIVE 08.05.13 AUTH *RAH*

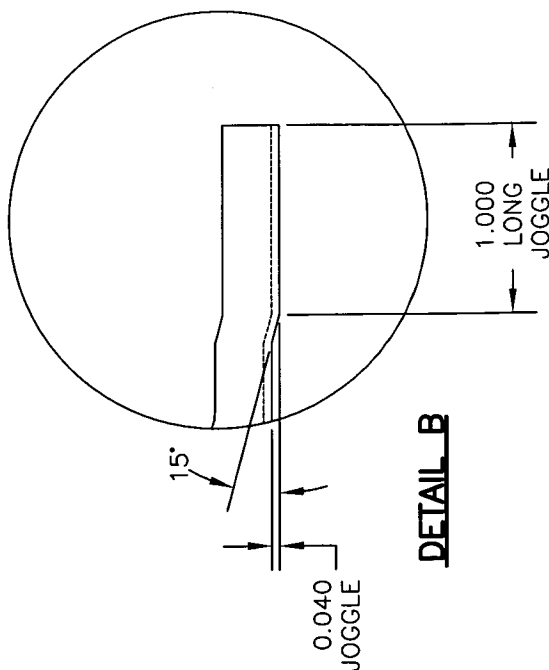
RELEASED *RAH* DATE 08.05.15

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3793	REV. A SHEET 3 OF 3
DATE 08.05.13	TITLE WEARSHOE		SCALE NTS

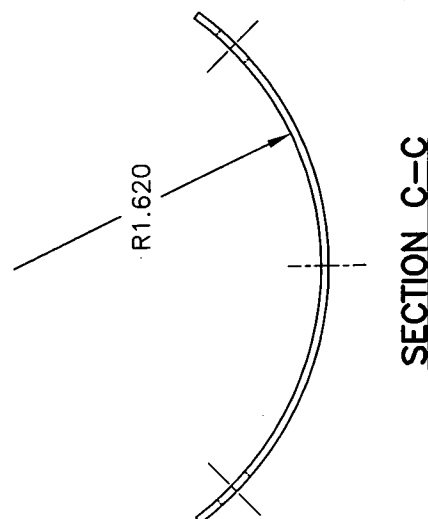
PRELIMINARY ISSUE
P4 08-05-14



DETAIL A



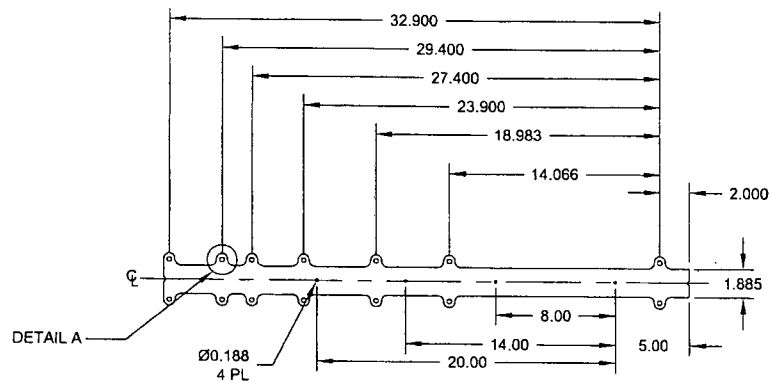
DETAIL B



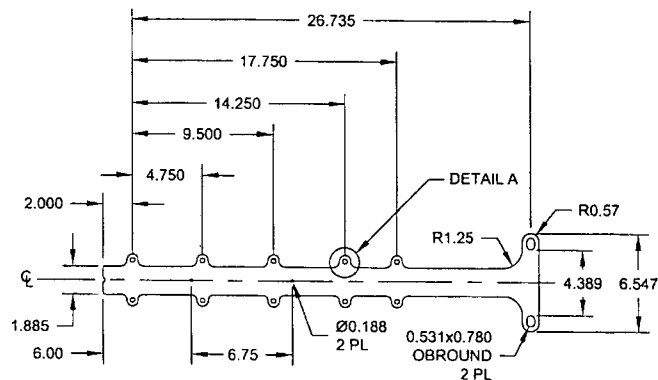
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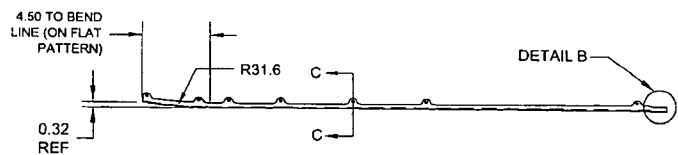
8 7 6 5 4 3 2 1



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

RELEASED
08.05.14

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

REV.	NEW ISSUE	DESCRIPTION	PH	08.05.14
DESIGN	PH		BY	DATE
DRAWN	PH			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.05.14			

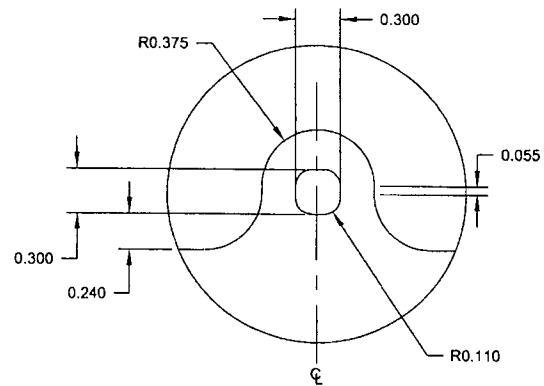
DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3793
TITLE WEARSHOE
SCALE NTS

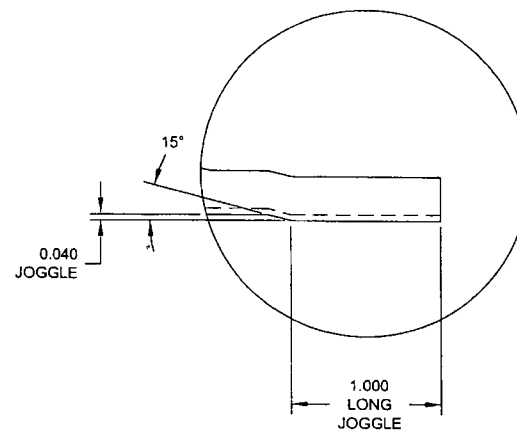
REV. A
SHEET 1 OF 2

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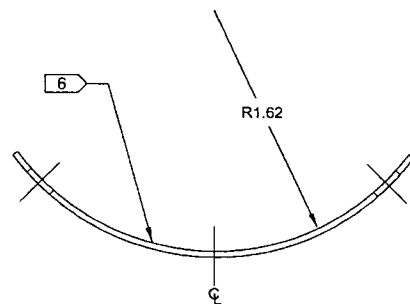
8 7 6 5 4 3 2 1



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X

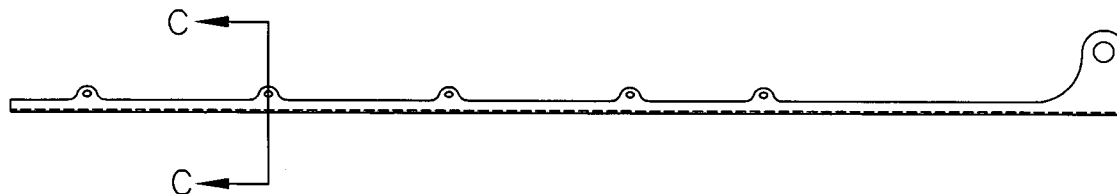
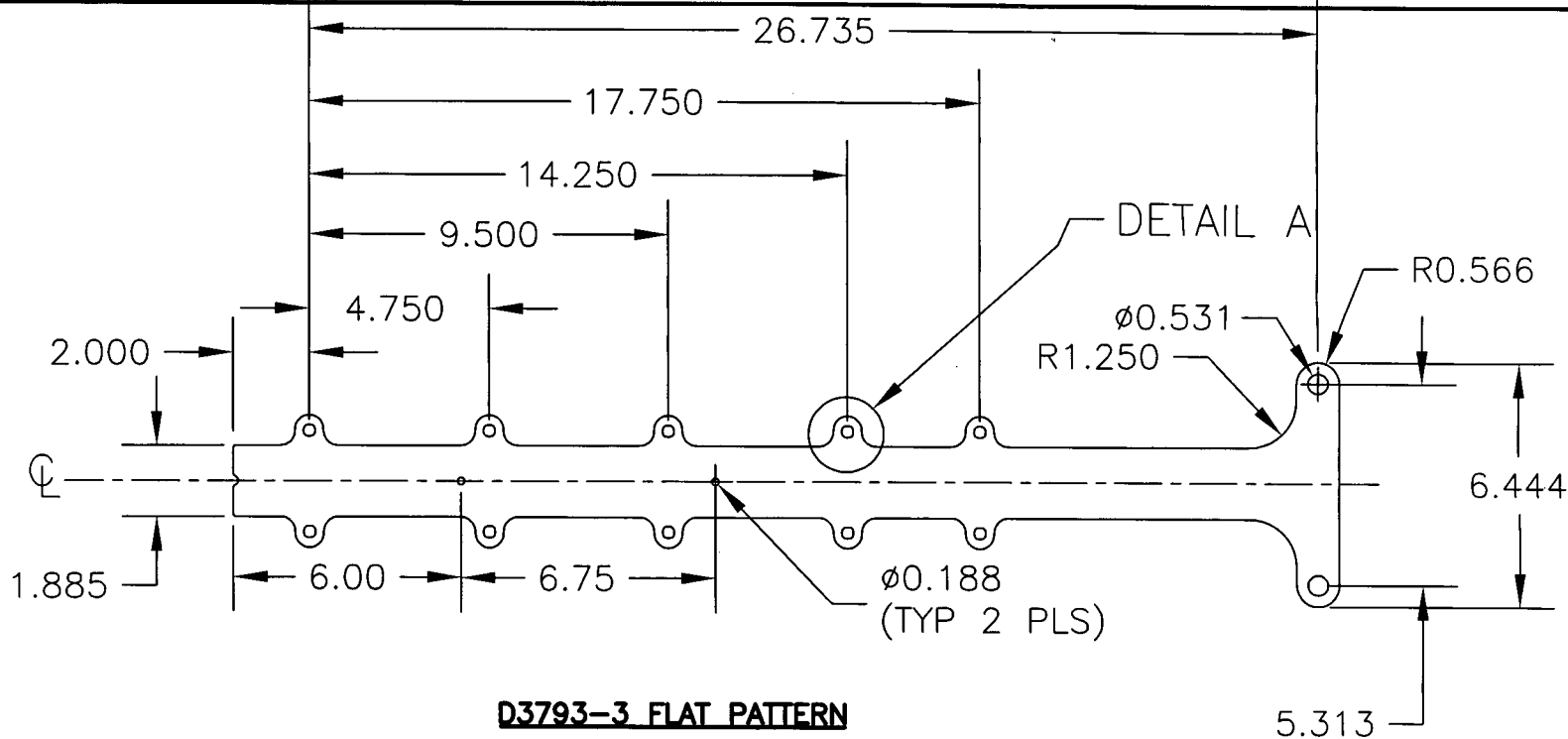


SECTION C-C
SCALE 10X

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08-05-14

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MFG. APPR.		D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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8 7 6 5 4 3 2 1



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT \bar{C}
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) SEE PAGE 3 FOR DETAILS AND SECTION

PRELIMINARY ISSUE

08.05.14

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08.05.13	D3793	SHEET 2 OF 3
	TITLE	SCALE
	WEARSHOE	NTS